

Work Order ID 130810

130810

Page 1

Wednesday, March 25, 2015 3:26:32 PM

Item ID: D4500-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bell Door Header, RH
 Start Date: 3/25/2015 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 4/10/2015 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: cmc Date: 15-3-26 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4500	pe1 E <u>15-05-26</u>								

100		0.00				2	0		J.C.L. 15/03/27
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	CUT BLANK 25.00" LONG								

110		0.00							
110									
Purchasing	Memo	0.00							
Purchasing	ISSUE P/O: <u>27949</u> TO WEJAY C OF C IS REQUIRED								

120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAG
38
9-89

2x 15-05-26
MAY 12 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Wednesday, March 25, 2015 3:26:32 PM

130810

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

~

~

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

**Insp.
Stamp**

0.00

130

Memo

0.00

HandFinish

Hand Finishing

DAS
28

9-89

MAY 13 2015

0.00

140

QC

Memo

0.00

Quality Control

②

FF

UAC
38
9-22

MAY 13 2015

0.00

150

SprayPaint

Memo

0.00

Spray Painting

PRIME TEMPO GREY AS PER DWG
BATCH: 131846

DAS
41
9-89

2

15-5-16

DQA: _____ Date: _____



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Handling/Pre									
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Training									
Transport									
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Page 3

Wednesday, March 25, 2015 3:26:32 PM

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 Required Date: 4/10/2015 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC14- Inspect Spray Paint	0.00							DAS 38 9-89
160						(2)			
QC	Memo	0.00							
Quality Control									MAY 2 1 2015
200	Identify as per dwg & Stock Location: <i>ml</i>	0.00				2			DAS 27 9-89
200									
Packaging	Memo	0.00							
Packaging									MAY 2 1 2015
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									MAY 2 2 2015

MLJ MAY 2 1 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
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Handling/Pre									
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Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Wednesday, March 25, 2015 3:26:31 PM

Page 1

Work Order ID: 130810

130810

Parent Item: D4500-2

D4500-2

Parent Item Name: Bell Door Header, RH

Start Date: 3/25/2015

Required Date: 4/10/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 12-12-11 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4500-2P		Purchased		No			Each	0.0000		2			
D4500-2P									**				
Bell Door Header, RH													
M6061T6B2.000X08.00		Purchased		No			f	9.8000		5			
0													
M6061T6B2 000X08 000									**				
6061-T6 BAR 2.00' X 8.00" (CUT IN 4FT SECTION)													

2X SP 15-05-12

J.C.M. 15/07/27

Location

Loc Qty

Loc Code

MAT007

9.8

125429

6

m127095

3.8

M130010

2.089'

2.088' -> Couldn't pull off the system

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

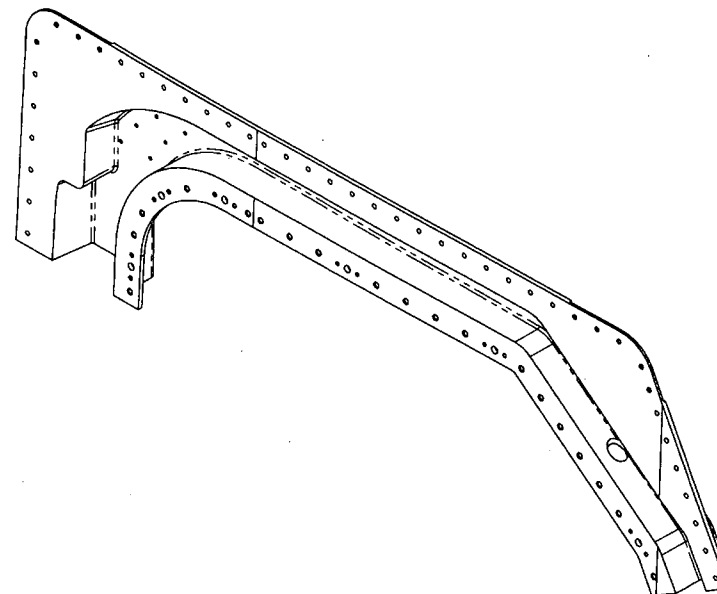
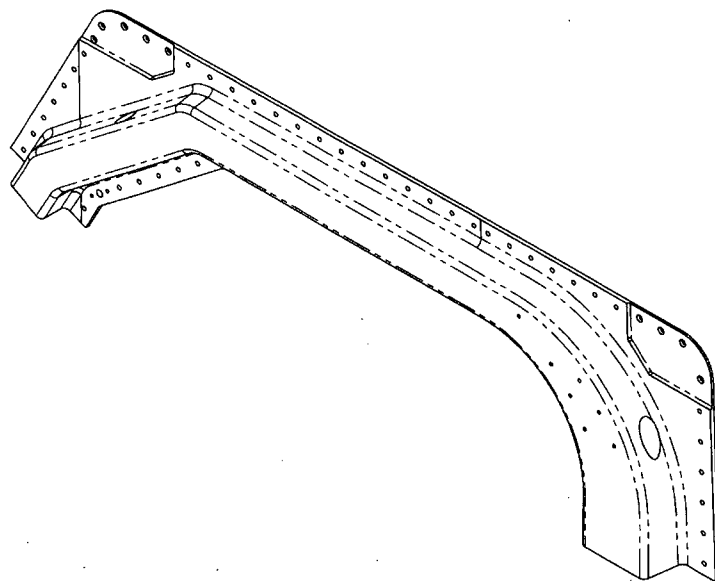
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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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D4500-2 BELL DOOR HEADER (RH)

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) RAW MATERIAL SURFACE FINISH SUFFICIENT FOR THIS PART
(NOT NECESSARY TO FACE MATERIAL)
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILE "D4500-2-REVE.STP"

RELEASED
2014-03-27

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>A.R.</i>	DRAWING NO. D4500	REV. E
MFG. APPR.	<i>[Signature]</i>	TITLE	SHEET 5 OF 8
APPROVED	<i>[Signature]</i>	BELL DOOR HEADER	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	14.03.24		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

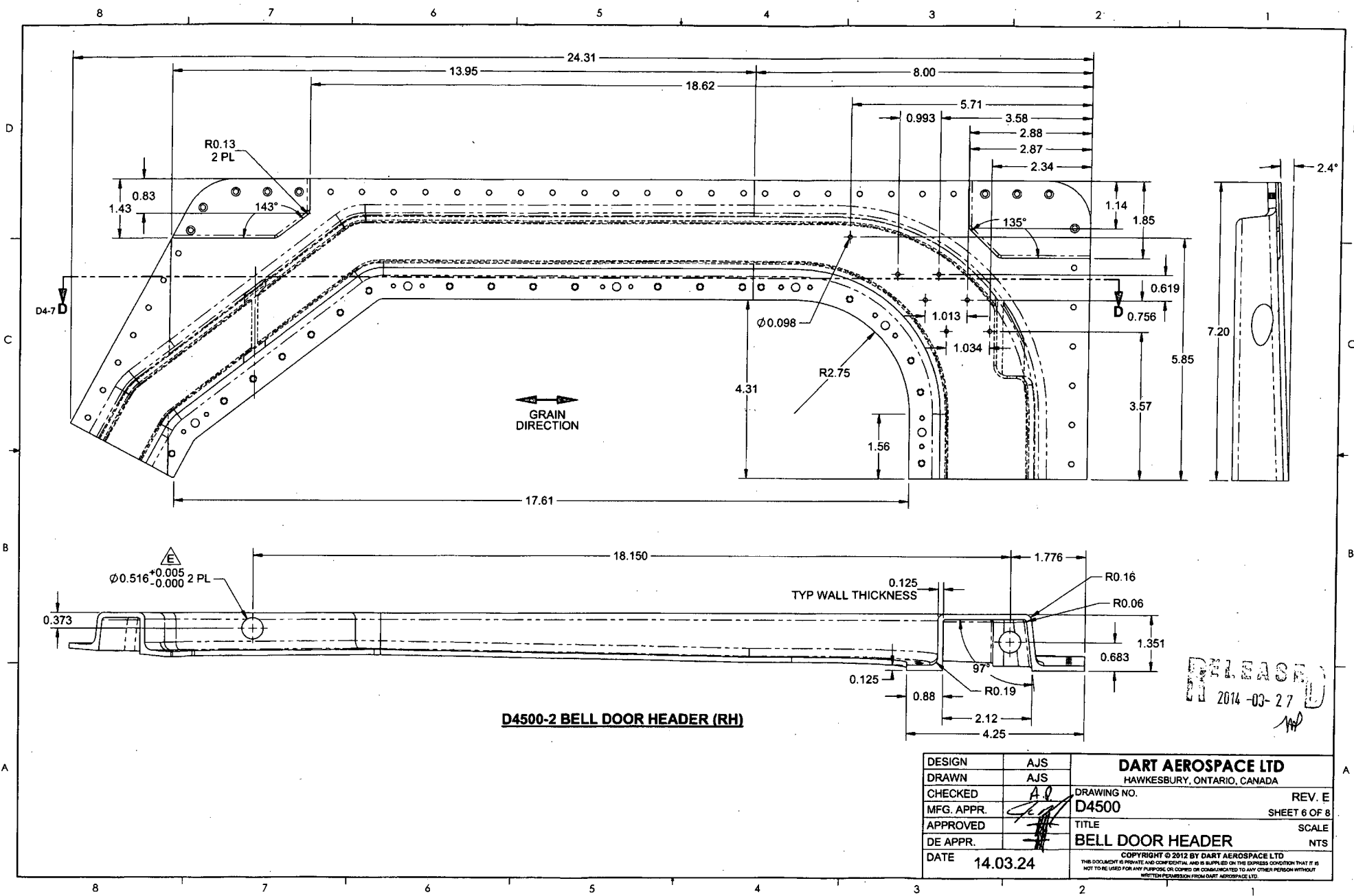
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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D4500-2 BELL DOOR HEADER (RH)

RELEASED
2014-03-27

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AJS	DRAWING NO.	REV. E
MFG. APPR.		D4500	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		BELL DOOR HEADER	NTS
DATE	14.03.24	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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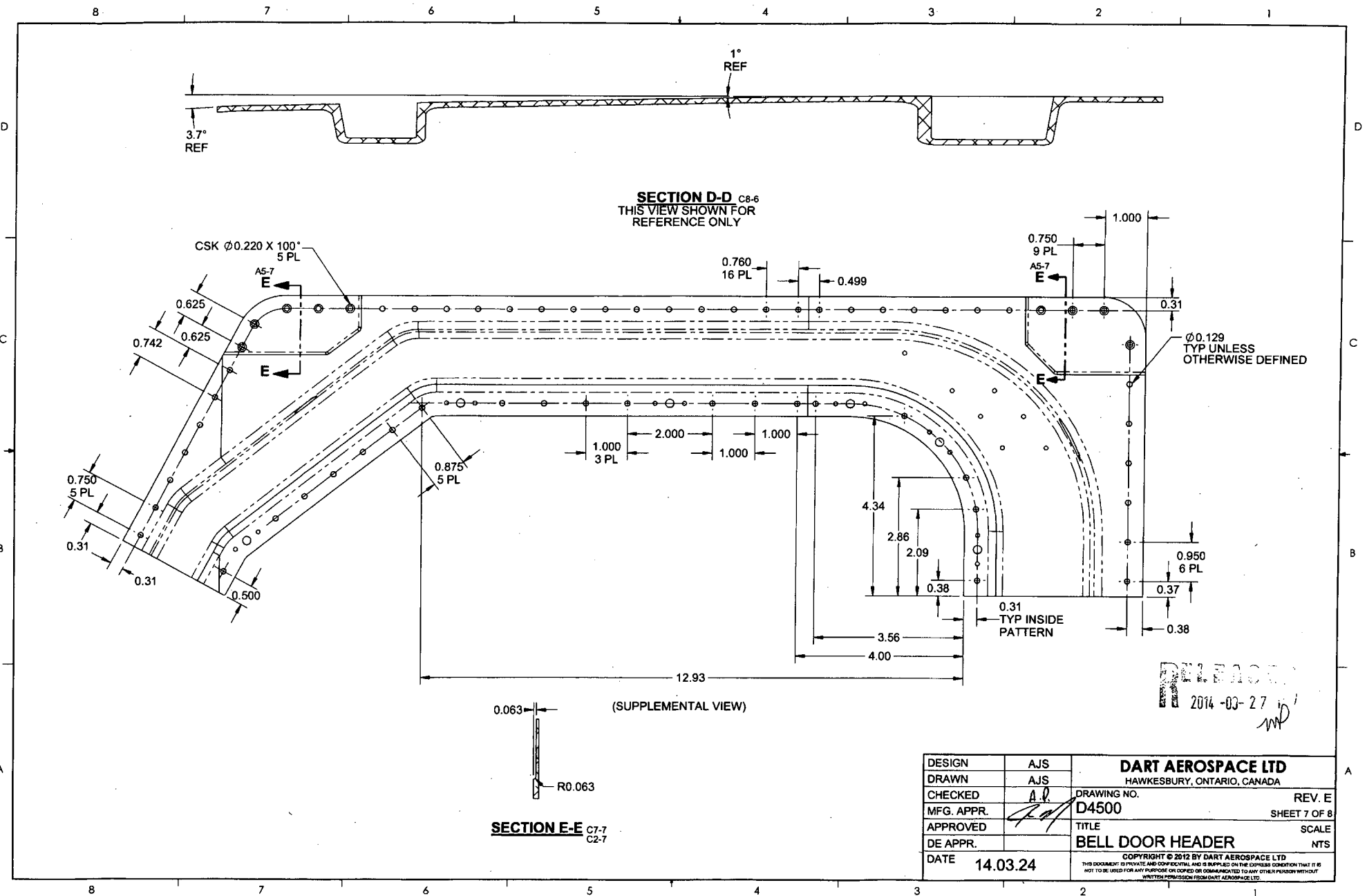
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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO. D4500	REV. E
MFG. APPR.		TITLE BELL DOOR HEADER	SHEET 7 OF 8
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	14.03.24		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

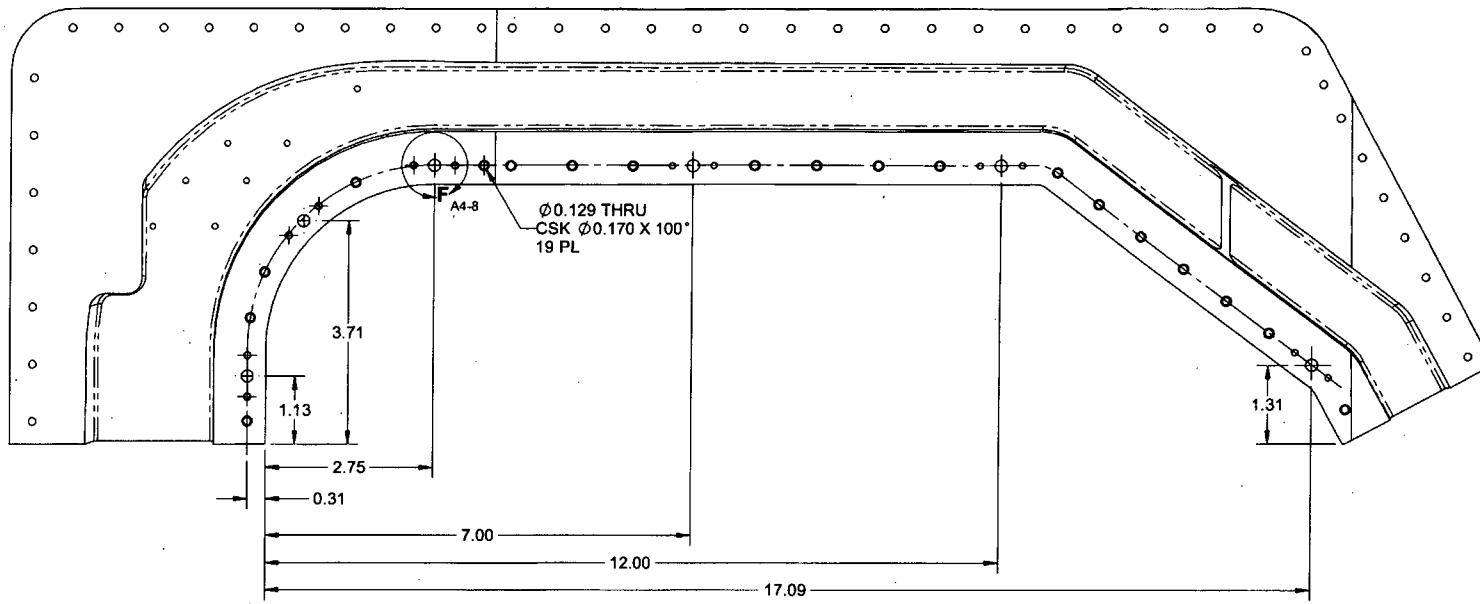
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

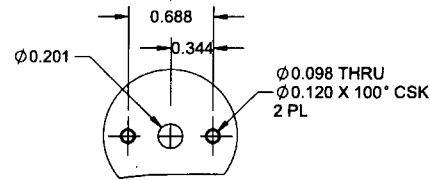
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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(SUPPLEMENTAL VIEW
NUTPLATE LOCATIONS)



DETAIL F C6-8
NUTPLATE HOLE DETAIL 6 PL
(SCALE 2X)

RELEASED
234-5-27-1

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. E
MFG. APPR.		D4500	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		BELL DOOR HEADER	NTS
DATE	14.03.24	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27949**

Purchase Order Date 3/30/2015

PO Print Date 3/30/2015

Page Number 1 of 2

Order From :

VC-WMP001

WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-384-1662

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

COD

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D4500-2P AS PER DWG D4500 REV. E B130810	Bell Door Header, RH	4/30/2015 Yes 4/30/2015		2.00 Each	\$1,997.50	\$3,995.00
						Line Total:	\$3,995.00
2	71401-45	PROCUREMENT QUALITY CLAUSES	4/30/2015 No 4/30/2015		1.00	\$0.00	\$0.00
Procurement Quality Clauses A005 RIGHT OF ENTRY A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE) A016 PERSONNEL QUALIFICATION A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE) A024 PROCESS CERTIFICATIONS A025 CERTIFICATE OF CONFORMANCE A040 NOTIFICATION OF QUALITY ESCAPE A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENTS							

Note:

3/30/2015

NO GOODS RETURNED WITHOUT
PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

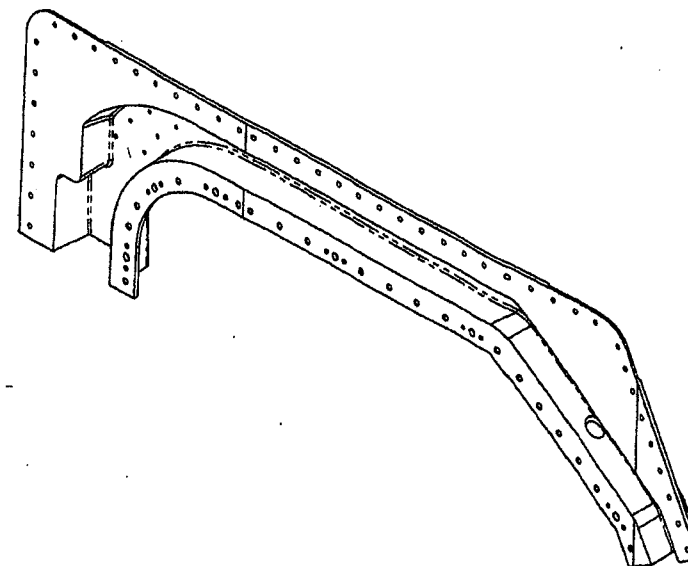
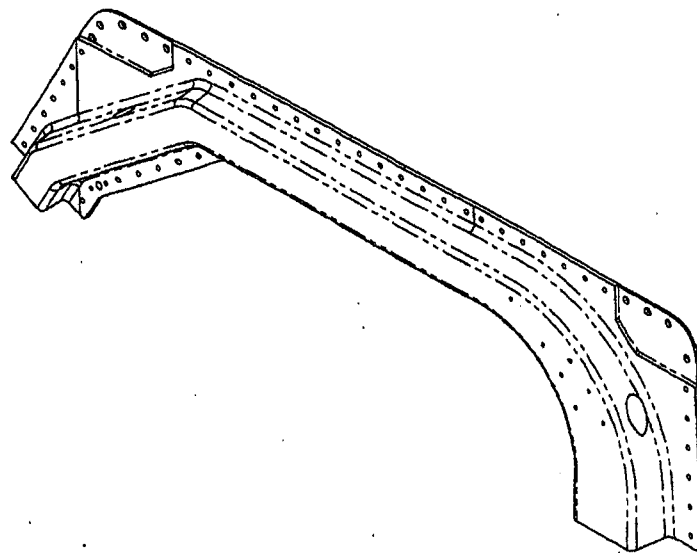
CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace	DATE: May 5, 2015		
	P.O.# PO27949		
	WEJAY JOB# 37291		
I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below. Any exceptions will be listed as NCR items.			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D4500-2P 'Bell Door Header R.H.' B130810	2	Machined complete per drawing req'ts.	D4500 / rev. E
<u>Note:</u> Inspection/ Test Report attached			

Records of Inspection/Test will be retained for 5 years minimum.

Yours truly,

Clifford Smith
Authorized Q.A. Signatory



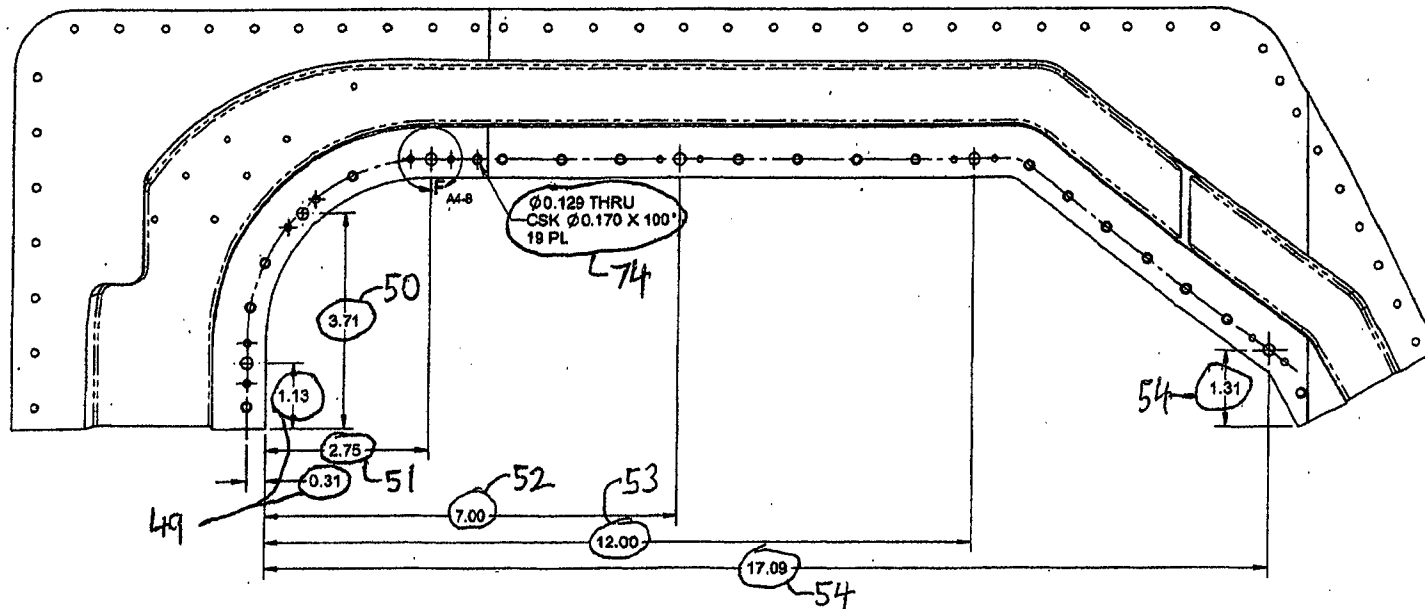
D4500-2 BELL DOOR HEADER (RH)

NOTES:

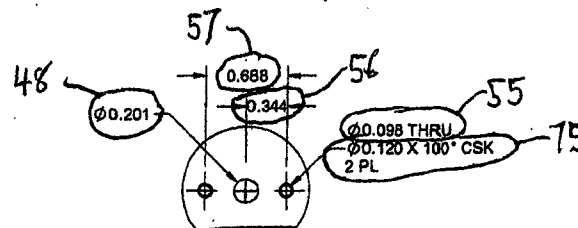
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M8081T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) RAW MATERIAL SURFACE FINISH SUFFICIENT FOR THIS PART
(NOT NECESSARY TO FACE MATERIAL)
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILE "D4500-2-REVE.STP"

RELEASED
2014-03-27
MP

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4500	REV. E
MFG. APPR.	<i>[Signature]</i>	SHEET 8 OF 8	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BELL DOOR HEADER	NTS
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(SUPPLEMENTAL VIEW
NUTPLATE LOCATIONS)



DETAIL F C6-8
NUTPLATE HOLE DETAIL 6 PL
(SCALE 2X)

RELEASED
11 2014-03-27
NMP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AR	DRAWING NO.	REV. E
MFG. APPR.		D4500	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		BELL DOOR HEADER	NTS
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Customer Dart Aerospace Customer P.O. PO27949
 Drawing # D4500 Drawing rev E
 Part Number D4500-2P E.C.O. -
 Part Name Bell Door Header R.H. Material Alum Alloy
 Serial # 37291-001 Inspected by Cliff Smith
 Job # 37291 Signature:



MAY 5/15



Overall Result

All Characteristics: 229
 Out of tolerance: 0
 Over Warning Limit: 0
 Not Calculated: 0

Comment:

Feature	ID	Actual	Nominal	Pos Tol.	Neg Tol.	Deviation	<- >
☐ 1 6_C1	Y	7.1985	7.2000	0.0300	-0.0300	-0.0015	-
☐ Inside bott. face_flat	GDT Flat	0.0032	0.0000	0.0100		0.0032	
☐ 2 6_A3	X	4.2528	4.2500	0.0300	-0.0300	0.0028	
☐ 4 6_B1	Z	1.3513	1.3510	0.0100	-0.0100	0.0003	
☐ 5 6_A3	CartDist	0.8825	0.8800	0.0300	-0.0300	0.0025	
☐ 6 6_A3_X	Dist	2.1249	2.1200	0.0300	-0.0300	0.0049	
☐ 7 6_A3	A	97.1565	97.0000	0.5000	-0.5000	0.1565	
☐ 8 6_C3	CartDist	1.5651	1.5600	0.0300	-0.0300	0.0051	
☐ 9A 6_C4	R	2.7479	2.7500	0.0300	-0.0300	-0.0021	-
☐ 9B 6_C4	Y	4.3091	4.3130	0.0100	-0.0100	-0.0039	-
☐ 10a 6_B7	D	0.5181	0.5160	0.0060	-0.0010	0.0021	-
☐ 10b 6_B7	D	0.5183	0.5160	0.0060	-0.0010	0.0023	-
☐ 11 6_B2	X	1.7753	1.7760	0.0100	-0.0100	-0.0007	-
☐ 12 6_A2	Z	-0.6819	-0.6830	0.0100	-0.0100	0.0011	
☐ 13 6_B8	Z	0.3746	0.3726	0.0100	-0.0100	0.0020	
☐ 14 6_B5_X	Dist	18.1513	18.1500	0.0100	-0.0100	0.0013	
☐ 15a 6_C4	D	0.0982	0.0980	0.0040	-0.0010	0.0002	-
☐ 16 6_D2	X	2.3397	2.3400	0.0300	-0.0300	-0.0003	-
☐ 17a 6_C2	Y	3.5717	3.5700	0.0300	-0.0300	0.0017	
☐ 15b 6_C4	D	0.0981	0.0980	0.0040	-0.0010	0.0001	-
☐ 17b 6_C2	Y	3.5714	3.5700	0.0300	-0.0300	0.0014	
☐ 18 6_C3_X	Dist	1.0345	1.0340	0.0100	-0.0100	0.0005	
☐ 15c 6_C4	D	0.0982	0.0980	0.0040	-0.0010	0.0002	-
☐ 19 6_D2	X	2.8807	2.8800	0.0300	-0.0300	0.0007	
☐ 20a 6_C2_Y	Dist	0.7563	0.7560	0.0100	-0.0100	0.0003	
☐ 15d 6_C4	D	0.0982	0.0980	0.0040	-0.0010	0.0002	-
☐ 20b 6_C2_Y	Dist	0.7560	0.7560	0.0100	-0.0100	0.0000	
☐ 21 6_C3_X	Dist	1.0136	1.0130	0.0100	-0.0100	0.0006	
☐ 15e 6_C4	D	0.0982	0.0980	0.0040	-0.0010	0.0002	-
☐ 22 6_D2	X	3.5752	3.5800	0.0300	-0.0300	-0.0048	-
☐ 23a 6_C2_Y	Dist	0.6185	0.6190	0.0100	-0.0100	-0.0005	-
☐ 15f 6_C4	D	0.0981	0.0980	0.0040	-0.0010	0.0001	-

Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-->
☐ 23b 6_C2_Y	Dist	0.6185	0.6190	0.0100	-0.0100	-0.0005	-
☐ 24 6_D3_X	Dist	0.9929	0.9930	0.0100	-0.0100	-0.0001	-
☐ 15g 6_C4	D	0.0982	0.0980	0.0040	-0.0010	0.0002	—
☐ 25 6_D3	X	5.7100	5.7100	0.0300	-0.0300	0.0000	
☐ 26 6_C1	Y	5.8461	5.8500	0.0300	-0.0300	-0.0039	-
☐ 27 6_D1	A2	2.3084	2.4000	0.5000	-0.5000	-0.0916	-
☐ 28 6_D5	X	24.3057	24.3100	0.0300	-0.0300	-0.0043	-
☐ 29 7_D4	A	0.9742	1.0000	0.5000	-0.5000	-0.0258	-
☐ 30 7_D7	A	3.6861	3.7000	0.5000	-0.5000	-0.0139	-
☐ 31 6_B5_X	Dist	17.6081	17.6100	0.0300	-0.0300	-0.0019	-
☐ 32a 7_C1(1)	D	0.1283	0.1290	0.0050	-0.0010	-0.0007	—
☐ 32a 7_C1(2)	D	0.1284	0.1290	0.0050	-0.0010	-0.0006	—
☐ 32a 7_C1(3)	D	0.1287	0.1290	0.0050	-0.0010	-0.0003	—
☐ 32a 7_C1(4)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—
☐ 32a 7_C1(5)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—
☐ 32a 7_C1(6)	D	0.1287	0.1290	0.0050	-0.0010	-0.0003	—
☐ 32a 7_C1(7)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—
☐ 33 7_B1(1)	GDT Po2d	0.0130	0.0000	0.0200		0.0130	—
	X	0.3753	0.3800			-0.0047	
	Y	0.3745	0.3700			0.0045	
☐ 33 7_B1(2)	GDT Po2d	0.0124	0.0000	0.0200		0.0124	—
	X	0.3754	0.3800			-0.0046	
	Y	1.3242	1.3200			0.0042	
☐ 33 7_B1(3)	GDT Po2d	0.0127	0.0000	0.0200		0.0127	—
	X	0.3753	0.3800			-0.0047	
	Y	2.2743	2.2700			0.0043	
☐ 33 7_B1(4)	GDT Po2d	0.0121	0.0000	0.0200		0.0121	—
	X	0.3755	0.3800			-0.0045	
	Y	3.2241	3.2200			0.0041	
☐ 33 7_B1(5)	GDT Po2d	0.0120	0.0000	0.0200		0.0120	—
	X	0.3756	0.3800			-0.0044	
	Y	4.1740	4.1700			0.0040	
☐ 33 7_B1(6)	GDT Po2d	0.0118	0.0000	0.0200		0.0118	—
	X	0.3756	0.3800			-0.0044	
	Y	5.1239	5.1200			0.0039	
☐ 33 7_B1(7)	GDT Po2d	0.0115	0.0000	0.0200		0.0115	—
	X	0.3756	0.3800			-0.0044	
	Y	6.0737	6.0700			0.0037	
☐ 32b 7_C1(1)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—
☐ 32b 7_C1(2)	D	0.1284	0.1290	0.0050	-0.0010	-0.0006	—
☐ 32b 7_C1(3)	D	0.1283	0.1290	0.0050	-0.0010	-0.0007	—
☐ 32b 7_C1(4)	D	0.1283	0.1290	0.0050	-0.0010	-0.0007	—
☐ 32b 7_C1(5)	D	0.1284	0.1290	0.0050	-0.0010	-0.0006	—
☐ 32b 7_C1(6)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—
☐ 32b 7_C1(7)	D	0.1284	0.1290	0.0050	-0.0010	-0.0006	—
☐ 32b 7_C1(8)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—
☐ 32b 7_C1(9)	D	0.1284	0.1290	0.0050	-0.0010	-0.0006	—
☐ 32b 7_C1(10)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—

Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-->
□ 34 7_C2(1)	GDT Po2d	0.0120	0.0000	0.0200		0.0120	├─
	X	1.0006	1.0000			0.0006	
	Y	-0.3160	-0.3100			-0.0060	
□ 34 7_C2(2)	GDT Po2d	0.0119	0.0000	0.0200		0.0119	├─
	X	1.7505	1.7500			0.0005	
	Y	-0.3159	-0.3100			-0.0059	
□ 34 7_C2(3)	GDT Po2d	0.0119	0.0000	0.0200		0.0119	├─
	X	2.5004	2.5000			0.0004	
	Y	-0.3159	-0.3100			-0.0059	
□ 34 7_C2(4)	GDT Po2d	0.0112	0.0000	0.0200		0.0112	├─
	X	3.2501	3.2500			0.0001	
	Y	-0.3156	-0.3100			-0.0056	
□ 34 7_C2(5)	GDT Po2d	0.0109	0.0000	0.0200		0.0109	├─
	X	3.9998	4.0000			-0.0002	
	Y	-0.3154	-0.3100			-0.0054	
□ 34 7_C2(6)	GDT Po2d	0.0106	0.0000	0.0200		0.0106	├─
	X	4.7499	4.7500			-0.0001	
	Y	-0.3153	-0.3100			-0.0053	
□ 34 7_C2(7)	GDT Po2d	0.0103	0.0000	0.0200		0.0103	├─
	X	5.4998	5.5000			-0.0002	
	Y	-0.3152	-0.3100			-0.0052	
□ 34 7_C2(8)	GDT Po2d	0.0102	0.0000	0.0200		0.0102	├─
	X	6.2496	6.2500			-0.0004	
	Y	-0.3151	-0.3100			-0.0051	
□ 34 7_C2(9)	GDT Po2d	0.0097	0.0000	0.0200		0.0097	├─
	X	6.9995	7.0000			-0.0005	
	Y	-0.3148	-0.3100			-0.0048	
□ 34 7_C2(10)	GDT Po2d	0.0096	0.0000	0.0200		0.0096	├─
	X	7.7495	7.7500			-0.0005	
	Y	-0.3148	-0.3100			-0.0048	
□ 32c 7_C1(1)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	├─
□ 32c 7_C1(2)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	├─
□ 32c 7_C1(3)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	├─
□ 32c 7_C1(4)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	├─
□ 32c 7_C1(5)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	├─
□ 32c 7_C1(6)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	├─
□ 32c 7_C1(7)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	├─
□ 32c 7_C1(8)	D	0.1284	0.1290	0.0050	-0.0010	-0.0006	├─
□ 32c 7_C1(9)	D	0.1284	0.1290	0.0050	-0.0010	-0.0006	├─
□ 32c 7_C1(10)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	├─
□ 32c 7_C1(11)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	├─
□ 32c 7_C1(12)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	├─
□ 32c 7_C1(13)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	├─
□ 32c 7_C1(14)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	├─
□ 32c 7_C1(15)	D	0.1302	0.1290	0.0050	-0.0010	0.0012	├─
□ 32c 7_C1(16)	D	0.1303	0.1290	0.0050	-0.0010	0.0013	├─
□ 32c 7_C1(17)	D	0.1302	0.1290	0.0050	-0.0010	0.0012	├─
□ 35 7_C4(1)	GDT Po2d	0.0098	0.0000	0.0200		0.0098	├─
	X	0.4999	0.4990			0.0009	
	Y	-0.3148	-0.3100			-0.0048	

Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<- >
□ 35 7_C4(2)	GDT Po2d	0.0096	0.0000	0.0200		0.0096	├─
	X	1.2599	1.2590			0.0009	
	Y	-0.3147	-0.3100			-0.0047	
□ 35 7_C4(3)	GDT Po2d	0.0094	0.0000	0.0200		0.0094	├─
	X	2.0197	2.0190			0.0007	
	Y	-0.3147	-0.3100			-0.0047	
□ 35 7_C4(4)	GDT Po2d	0.0094	0.0000	0.0200		0.0094	├─
	X	2.7797	2.7790			0.0007	
	Y	-0.3146	-0.3100			-0.0046	
□ 35 7_C4(5)	GDT Po2d	0.0092	0.0000	0.0200		0.0092	├─
	X	3.5396	3.5390			0.0006	
	Y	-0.3146	-0.3100			-0.0046	
□ 35 7_C4(6)	GDT Po2d	0.0092	0.0000	0.0200		0.0092	├─
	X	4.2995	4.2990			0.0005	
	Y	-0.3146	-0.3100			-0.0046	
□ 35 7_C4(7)	GDT Po2d	0.0090	0.0000	0.0200		0.0090	├─
	X	5.0594	5.0590			0.0004	
	Y	-0.3145	-0.3100			-0.0045	
□ 35 7_C4(8)	GDT Po2d	0.0088	0.0000	0.0200		0.0088	├─
	X	5.8194	5.8190			0.0004	
	Y	-0.3144	-0.3100			-0.0044	
□ 35 7_C4(9)	GDT Po2d	0.0085	0.0000	0.0200		0.0085	├─
	X	6.5791	6.5790			0.0001	
	Y	-0.3142	-0.3100			-0.0042	
□ 35 7_C4(10)	GDT Po2d	0.0084	0.0000	0.0200		0.0084	├─
	X	7.3391	7.3390			0.0001	
	Y	-0.3142	-0.3100			-0.0042	
□ 35 7_C4(11)	GDT Po2d	0.0081	0.0000	0.0200		0.0081	├─
	X	8.0991	8.0990			0.0001	
	Y	-0.3141	-0.3100			-0.0041	
□ 35 7_C4(12)	GDT Po2d	0.0079	0.0000	0.0200		0.0079	├─
	X	8.8589	8.8590			-0.0001	
	Y	-0.3140	-0.3100			-0.0040	
□ 35 7_C4(13)	GDT Po2d	0.0076	0.0000	0.0200		0.0076	├─
	X	9.6188	9.6190			-0.0002	
	Y	-0.3138	-0.3100			-0.0038	
□ 35 7_C4(14)	GDT Po2d	0.0076	0.0000	0.0200		0.0076	├─
	X	10.3787	10.3790			-0.0003	
	Y	-0.3138	-0.3100			-0.0038	
□ 35 7_C4(15)	GDT Po2d	0.0078	0.0000	0.0200		0.0078	├─
	X	11.1386	11.1390			-0.0004	
	Y	-0.3139	-0.3100			-0.0039	
□ 35 7_C4(16)	GDT Po2d	0.0075	0.0000	0.0200		0.0075	├─
	X	11.8987	11.8990			-0.0003	
	Y	-0.3137	-0.3100			-0.0037	
□ 35 7_C4(17)	GDT Po2d	0.0074	0.0000	0.0200		0.0074	├─
	X	12.6587	12.6590			-0.0003	
	Y	-0.3137	-0.3100			-0.0037	
□ 32d 7_C1(1)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	─┤
□ 32d 7_C1(2)	D	0.1284	0.1290	0.0050	-0.0010	-0.0006	─┤
□ 32d 7_C1(3)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	─┤
□ 32d 7_C1(4)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	─┤
□ 32d 7_C1(5)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	─┤
□ 32d 7_C1(6)	D	0.1287	0.1290	0.0050	-0.0010	-0.0003	─┤

Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-- -->
☐ 36 7_B8(1)	GDT Po2d	0.0107	0.0000	0.0200		0.0107	—
	X	-0.3047	-0.3100			0.0053	
	Y	0.3106	0.3100			0.0006	
☐ 36 7_B8(2)	GDT Po2d	0.0091	0.0000	0.0200		0.0091	—
	X	-0.3055	-0.3100			0.0045	
	Y	1.0605	1.0600			0.0005	
☐ 36 7_B8(3)	GDT Po2d	0.0084	0.0000	0.0200		0.0084	—
	X	-0.3059	-0.3100			0.0041	
	Y	1.8108	1.8100			0.0008	
☐ 36 7_B8(4)	GDT Po2d	0.0072	0.0000	0.0200		0.0072	—
	X	-0.3065	-0.3100			0.0035	
	Y	2.5608	2.5600			0.0008	
☐ 36 7_B8(5)	GDT Po2d	0.0064	0.0000	0.0200		0.0064	—
	X	-0.3069	-0.3100			0.0031	
	Y	3.3108	3.3100			0.0008	
☐ 36 7_B8(6)	GDT Po2d	0.0059	0.0000	0.0200		0.0059	—
	X	-0.3072	-0.3100			0.0028	
	Y	4.0609	4.0600			0.0009	
☐ 32e 7_C1	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—
☐ 37 7_B9	GDT Po2d	0.0096	0.0000	0.0200		0.0096	—
	X	-0.3136	-0.3100			-0.0036	
	Y	0.7418	0.7450			-0.0032	
☐ 32f 7_C8(1)	D	0.1284	0.1290	0.0050	-0.0010	-0.0006	—
☐ 32f 7_C8(2)	D	0.1282	0.1290	0.0050	-0.0010	-0.0008	—
☐ 38 7_C7(1)	GDT Po2d	0.0063	0.0000	0.0200		0.0063	—
	X	-0.3132	-0.3100			-0.0032	
	Y	0.6251	0.6250			0.0001	
☐ 38 7_C7(2)	GDT Po2d	0.0053	0.0000	0.0200		0.0053	—
	X	-0.3126	-0.3100			-0.0026	
	Y	1.2500	1.2500			0.0000	
☐ 32g 7_C1	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—
☐ 39 7_B3	GDT Po2d	0.0195	0.0000	0.0200		0.0195	—
	X	-0.3197	-0.3100			-0.0097	
	Y	0.3793	0.3800			-0.0007	
☐ 32h 7_C1	D	0.1287	0.1290	0.0050	-0.0010	-0.0003	—
☐ 40 7_B3	GDT Po2d	0.0169	0.0000	0.0200		0.0169	—
	X	-0.2744	-0.2660			-0.0084	
	Y	2.1003	2.1000			0.0003	
☐ 32i 7_C1	D	0.1287	0.1285	0.0050	-0.0010	0.0002	—
☐ 41 7_B3	GDT Po2d	0.0187	0.0000	0.0200		0.0187	—
	X	-0.0339	-0.0250			-0.0089	
	Y	2.8629	2.8600			0.0029	
☐ 32j 7_C1	D	0.1290	0.1290	0.0050	-0.0010	0.0000	—
☐ 42 7_B3	GDT Po2d	0.0189	0.0000	0.0200		0.0189	—
	X	1.4475	1.4560			-0.0085	
	Y	4.3441	4.3400			0.0041	
☐ 32k 7_C1	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—
☐ 43 7_B3	GDT Po2d	0.0093	0.0000	0.0200		0.0093	—
	X	3.5614	3.5600			0.0014	
	Y	0.3145	0.3100			0.0045	
☐ 32L 7_C1(1)	D	0.1287	0.1290	0.0050	-0.0010	-0.0003	—
☐ 32L 7_C1(2)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—
☐ 32L 7_C1(3)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—

Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-->
☐ 32L 7_C1(4)	D	0.1284	0.1290	0.0050	-0.0010	-0.0006	—
☐ 32L 7_C1(5)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—
☐ 32L 7_C1(6)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—
☐ 32L 7_C1(7)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—
☐ 44 7_B3,B4(1)	GDT Po2d	0.0056	0.0000	0.0200		0.0056	├
	X	3.9986	4.0000			-0.0014	
	Y	0.3124	0.3100			0.0024	
☐ 44 7_B3,B4(2)	GDT Po2d	0.0058	0.0000	0.0200		0.0058	├
	X	4.9986	5.0000			-0.0014	
	Y	0.3125	0.3100			0.0025	
☐ 44 7_B3,B4(3)	GDT Po2d	0.0061	0.0000	0.0200		0.0061	├
	X	5.9986	6.0000			-0.0014	
	Y	0.3127	0.3100			0.0027	
☐ 44 7_B3,B4(4)	GDT Po2d	0.0068	0.0000	0.0200		0.0068	├
	X	7.9986	8.0000			-0.0014	
	Y	0.3131	0.3100			0.0031	
☐ 44 7_B3,B4(5)	GDT Po2d	0.0076	0.0000	0.0200		0.0076	├
	X	8.9986	9.0000			-0.0014	
	Y	0.3135	0.3100			0.0035	
☐ 44 7_B3,B4(6)	GDT Po2d	0.0079	0.0000	0.0200		0.0079	├
	X	9.9985	10.0000			-0.0015	
	Y	0.3137	0.3100			0.0037	
☐ 44 7_B3,B4(7)	GDT Po2d	0.0086	0.0000	0.0200		0.0086	├
	X	10.9984	11.0000			-0.0016	
	Y	0.3140	0.3100			0.0040	
☐ 32m 7_C1	D	0.1288	0.1290	0.0050	-0.0010	-0.0002	—
☐ 45 7_A4	GDT Po2d	0.0197	0.0000	0.0200		0.0197	├
	X	12.9203	12.9300			-0.0097	
	Y	4.5215	4.5200			0.0015	
☐ 32n 7_C1(1)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—
☐ 32n 7_C1(2)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—
☐ 32n 7_C1(3)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—
☐ 32n 7_C1(4)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—
☐ 32n 7_C1(5)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—
☐ 46 7_B6(1)	GDT Po2d	0.0027	0.0000	0.0200		0.0027	├
	X	0.8763	0.8750			0.0013	
	Y	0.3100	0.3100			0.0000	
☐ 46 7_B6(2)	GDT Po2d	0.0028	0.0000	0.0200		0.0028	├
	X	1.7514	1.7500			0.0014	
	Y	0.3100	0.3100			0.0000	
☐ 46 7_B6(3)	GDT Po2d	0.0028	0.0000	0.0200		0.0028	├
	X	2.6264	2.6250			0.0014	
	Y	0.3101	0.3100			0.0001	
☐ 46 7_B6(4)	GDT Po2d	0.0028	0.0000	0.0200		0.0028	├
	X	3.5014	3.5000			0.0014	
	Y	0.3102	0.3100			0.0002	
☐ 46 7_B6(5)	GDT Po2d	0.0028	0.0000	0.0200		0.0028	├
	X	4.3764	4.3750			0.0014	
	Y	0.3102	0.3100			0.0002	
☐ 32o 7_C1	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—
☐ 47 7_B7	GDT Po2d	0.0029	0.0000	0.0200		0.0029	├
	X	0.3114	0.3100			0.0014	
	Y	0.4995	0.5000			-0.0005	

Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<- >
☐ 48a 8_A5	D	0.2037	0.2010	0.0050	-0.0010	0.0027	┆
☐ 49 8_C6	GDT Po2d	0.0227	0.0000	0.0600		0.0227	┆
	X	-0.3213	-0.3100			-0.0113	
	Y	1.1298	1.1300			-0.0002	
☐ 48b 8_A5	D	0.2036	0.2010	0.0050	-0.0010	0.0026	┆
☐ 50 8_C6	GDT Po2d	0.0185	0.0000	0.0600		0.0185	┆
	X	0.5971	0.6060			-0.0089	
	Y	3.7127	3.7100			0.0027	
☐ 48c 8_A5	D	0.2039	0.2010	0.0050	-0.0010	0.0029	┆
☐ 51 8_C7	GDT Po2d	0.0143	0.0000	0.0600		0.0143	┆
	X	2.7450	2.7500			-0.0050	
	Y	0.3151	0.3100			0.0051	
☐ 48d 8_A5	D	0.2037	0.2010	0.0050	-0.0010	0.0027	┆
☐ 52 8_B6	GDT Po2d	0.0057	0.0000	0.0600		0.0057	┆
	X	6.9984	7.0000			-0.0016	
	Y	0.3124	0.3100			0.0024	
☐ 48e 8_A5	D	0.2036	0.2010	0.0050	-0.0010	0.0026	┆
☐ 53 8_B5	GDT Po2d	0.0080	0.0000	0.0600		0.0080	┆
	X	11.9983	12.0000			-0.0017	
	Y	0.3136	0.3100			0.0036	
☐ 48f 8_A5	D	0.2038	0.2010	0.0050	-0.0010	0.0028	┆
☐ 54 8_B4,C2	GDT Po2d	0.0278	0.0000	0.0600		0.0278	┆
	X	17.0861	17.0900			-0.0039	
	Y	1.3233	1.3100			0.0133	
☐ 55a 8_A4(1)	D	0.0985	0.0980	0.0040	-0.0010	0.0005	-┆
☐ 55a 8_A4(2)	D	0.0985	0.0980	0.0040	-0.0010	0.0005	-┆
☐ 56a 8_A4(1)	GDT Po2d	0.0004	0.0000	0.0600		0.0004	┆
	X	0.0001	0.0000			0.0001	
	Y	-0.3438	-0.3440			0.0002	
☐ 56a 8_A4(2)	GDT Po2d	0.0008	0.0000	0.0600		0.0008	┆
	X	0.0004	0.0000			0.0004	
	Y	0.3441	0.3440			0.0001	
☐ 57a 8_A4_R	Dist	0.6873	0.6880	0.0100	-0.0100	-0.0007	-┆
☐ 55b 8_A4(1)	D	0.0982	0.0980	0.0040	-0.0010	0.0002	-┆
☐ 55b 8_A4(2)	D	0.0983	0.0980	0.0040	-0.0010	0.0003	-┆
☐ 56b 8_A4(1)	GDT Po2d	0.0010	0.0000	0.0600		0.0010	┆
	X	0.0001	0.0000			0.0001	
	Y	-0.3435	-0.3440			0.0005	
☐ 56b 8_A4(2)	GDT Po2d	0.0013	0.0000	0.0600		0.0013	┆
	X	0.0003	0.0000			0.0003	
	Y	0.3446	0.3440			0.0006	
☐ 57b 8_A4_R	Dist	0.6878	0.6880	0.0100	-0.0100	-0.0002	-┆
☐ 55c 8_A4(1)	D	0.0984	0.0980	0.0040	-0.0010	0.0004	-┆
☐ 55c 8_A4(2)	D	0.0984	0.0980	0.0040	-0.0010	0.0004	-┆
☐ 56c 8_A4(1)	GDT Po2d	0.0005	0.0000	0.0600		0.0005	┆
	X	-0.3439	-0.3440			0.0001	
	Y	-0.0002	0.0000			-0.0002	
☐ 56c 8_A4(2)	GDT Po2d	0.0006	0.0000	0.0600		0.0006	┆
	X	0.3442	0.3440			0.0002	
	Y	-0.0002	0.0000			-0.0002	
☐ 57c 8_A4_R	Dist	0.6881	0.6880	0.0100	-0.0100	0.0001	┆
☐ 55d 8_A4(1)	D	0.0984	0.0980	0.0040	-0.0010	0.0004	-┆

Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<- ->
☐ 55d 8_A4(2)	D	0.0985	0.0980	0.0040	-0.0010	0.0005	-
☐ 56d 8_A4(1)	GDT Po2d	0.0007	0.0000	0.0600		0.0007	
	X	-0.3438	-0.3440			0.0002	
	Y	-0.0002	0.0000			-0.0002	
☐ 56d 8_A4(2)	GDT Po2d	0.0007	0.0000	0.0600		0.0007	
	X	0.3443	0.3440			0.0003	
	Y	0.0002	0.0000			0.0002	
☐ 57d 8_A4_R	Dist	0.6879	0.6880	0.0100	-0.0100	-0.0001	-
☐ 55e 8_A4(1)	D	0.0985	0.0980	0.0040	-0.0010	0.0005	-
☐ 55e 8_A4(2)	D	0.0985	0.0980	0.0040	-0.0010	0.0005	-
☐ 56e 8_A4(1)	GDT Po2d	0.0013	0.0000	0.0600		0.0013	
	X	-0.3439	-0.3440			0.0001	
	Y	-0.0006	0.0000			-0.0006	
☐ 56e 8_A4(2)	GDT Po2d	0.0016	0.0000	0.0600		0.0016	
	X	0.3441	0.3440			0.0001	
	Y	0.0008	0.0000			0.0008	
☐ 57e 8_A4_R	Dist	0.6879	0.6880	0.0100	-0.0100	-0.0001	-
☐ 55f 8_A4(1)	D	0.0986	0.0980	0.0040	-0.0010	0.0006	-
☐ 55f 8_A4(2)	D	0.0985	0.0980	0.0040	-0.0010	0.0005	-
☐ 56f 8_A4(1)	GDT Po2d	0.0006	0.0000	0.0600		0.0006	
	X	-0.3437	-0.3440			0.0003	
	Y	0.0000	0.0000			0.0000	
☐ 56f 8_A4(2)	GDT Po2d	0.0008	0.0000	0.0600		0.0008	
	X	0.3444	0.3440			0.0004	
	Y	-0.0001	0.0000			-0.0001	
☐ 57f 8_A4_R	Dist	0.6881	0.6880	0.0100	-0.0100	0.0001	

Manually Inspected Dims

58	6_B3	.125 typ. wall thickness	<u>.1245/.127</u>
59	6_A3	.125 typ. flange thk	<u>.118/.129</u>
60	6_B2	R.06	<u>R.06 typ</u>
61	6_B2	R.16	<u>R.16 typ</u>
62	6_D2	2.87 dim	<u>2.91</u>
63	6_D2	1.85 dim	<u>1.89</u>
64	6_D2	1.14 dim	<u>1.15</u>
65	6_D2	135 deg angle	<u>135°</u>
66	6_D4	18.62 dim	<u>18.58</u>
67	6_D8	1.43 dim	<u>1.468</u>
68	6_D8	0.83 dim	<u>.84</u>
69	6_D7	143 deg angle	<u>143°</u>
70	6_D7	R0.13 typ	<u>R.15 typ</u>
71	7_C7	CSK .220 dia x 100 deg	<u>.225/.230 x 100°</u>
72	7_A6	0.063 dim typ.	<u>.063/.065</u>
73	7_A5	R0.063 typ.	<u>R.125 typ</u>
74	8_C5	CSK .170 dia x 100 deg	<u>.162/.165 x 100°</u>
75	8_C5	CSK .120 dia x 100 deg	<u>.115/.117 x 100°</u>



Customer Dart Aerospace Customer P.O. PO27949
 Drawing # D4500 Drawing rev E
 Part Number D4500-2P E.C.O. -
 Part Name Bell Door Header R.H. Material Alum Alloy
 Serial # 37291-002 Inspected by Cliff Smith
 Job # 37291 Signature:



MAY 5/15



Overall Result

All Characteristics: 229
 Out of tolerance: 0
 Over Warning Limit: 0
 Not Calculated: 0

Comment:

Feature	ID	Actual	Nominal	Pos Tol.	Neg Tol.	Deviation	<+>
☐ 1 6_C1	Y	7.1988	7.2000	0.0300	-0.0300	-0.0012	-
☐ Inside bott. face_flat	GDT Flat	0.0012	0.0000	0.0100		0.0012	
☐ 2 6_A3	X	4.2488	4.2500	0.0300	-0.0300	-0.0012	-
☐ 4 6_B1	Z	1.3506	1.3510	0.0100	-0.0100	-0.0004	-
☐ 5 6_A3	CartDist	0.8774	0.8800	0.0300	-0.0300	-0.0026	-
☐ 6 6_A3_X	Dist	2.1213	2.1200	0.0300	-0.0300	0.0013	
☐ 7 6_A3	A	97.0080	97.0000	0.5000	-0.5000	0.0080	
☐ 8 6_C3	CartDist	1.5654	1.5600	0.0300	-0.0300	0.0054	
☐ 9A 6_C4	R	2.7485	2.7500	0.0300	-0.0300	-0.0015	-
☐ 9B 6_C4	Y	4.3093	4.3130	0.0100	-0.0100	-0.0037	-
☐ 10a 6_B7	D	0.5192	0.5160	0.0060	-0.0010	0.0032	
☐ 10b 6_B7	D	0.5186	0.5160	0.0060	-0.0010	0.0026	
☐ 11 6_B2	X	1.7757	1.7760	0.0100	-0.0100	-0.0003	-
☐ 12 6_A2	Z	-0.6834	-0.6830	0.0100	-0.0100	-0.0004	-
☐ 13 6_B8	Z	0.3728	0.3726	0.0100	-0.0100	0.0002	
☐ 14 6_B5_X	Dist	18.1527	18.1500	0.0100	-0.0100	0.0027	
☐ 15a 6_C4	D	0.0981	0.0980	0.0040	-0.0010	0.0001	-
☐ 16 6_D2	X	2.3412	2.3400	0.0300	-0.0300	0.0012	
☐ 17a 6_C2	Y	3.5729	3.5700	0.0300	-0.0300	0.0029	
☐ 15b 6_C4	D	0.0981	0.0980	0.0040	-0.0010	0.0001	-
☐ 17b 6_C2	Y	3.5728	3.5700	0.0300	-0.0300	0.0028	
☐ 18 6_C3_X	Dist	1.0345	1.0340	0.0100	-0.0100	0.0005	
☐ 15c 6_C4	D	0.0982	0.0980	0.0040	-0.0010	0.0002	-
☐ 19 6_D2	X	2.8824	2.8800	0.0300	-0.0300	0.0024	
☐ 20a 6_C2_Y	Dist	0.7566	0.7560	0.0100	-0.0100	0.0006	
☐ 15d 6_C4	D	0.0978	0.0980	0.0040	-0.0010	-0.0002	-
☐ 20b 6_C2_Y	Dist	0.7560	0.7560	0.0100	-0.0100	0.0000	
☐ 21 6_C3_X	Dist	1.0132	1.0130	0.0100	-0.0100	0.0002	
☐ 15e 6_C4	D	0.0981	0.0980	0.0040	-0.0010	0.0001	-
☐ 22 6_D2	X	3.5765	3.5800	0.0300	-0.0300	-0.0035	-
☐ 23a 6_C2_Y	Dist	0.6187	0.6190	0.0100	-0.0100	-0.0003	-
☐ 15f 6_C4	D	0.0979	0.0980	0.0040	-0.0010	-0.0001	-

Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<— —>
□ 23b 6_C2_Y	Dist	0.6183	0.6190	0.0100	-0.0100	-0.0007	—
□ 24 6_D3_X	Dist	0.9929	0.9930	0.0100	-0.0100	-0.0001	—
□ 15g 6_C4	D	0.0981	0.0980	0.0040	-0.0010	0.0001	—
□ 25 6_D3	X	5.7113	5.7100	0.0300	-0.0300	0.0013	—
□ 26 6_C1	Y	5.8472	5.8500	0.0300	-0.0300	-0.0028	—
□ 27 6_D1	A2	2.3460	2.4000	0.5000	-0.5000	-0.0540	—
□ 28 6_D5	X	24.3086	24.3100	0.0300	-0.0300	-0.0014	—
□ 29 7_D4	A	1.0327	1.0000	0.5000	-0.5000	0.0327	—
□ 30 7_D7	A	3.7693	3.7000	0.5000	-0.5000	0.0693	—
□ 31 6_B5_X	Dist	17.6109	17.6100	0.0300	-0.0300	0.0009	—
□ 32a 7_C1(1)	D	0.1284	0.1290	0.0050	-0.0010	-0.0006	—
□ 32a 7_C1(2)	D	0.1284	0.1290	0.0050	-0.0010	-0.0006	—
□ 32a 7_C1(3)	D	0.1284	0.1290	0.0050	-0.0010	-0.0006	—
□ 32a 7_C1(4)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—
□ 32a 7_C1(5)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—
□ 32a 7_C1(6)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—
□ 32a 7_C1(7)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—
□ 33 7_B1(1)	GDT Po2d	0.0144	0.0000	0.0200		0.0144	—
	X	0.3761	0.3800			-0.0039	
	Y	0.3761	0.3700			0.0061	
□ 33 7_B1(2)	GDT Po2d	0.0140	0.0000	0.0200		0.0140	—
	X	0.3763	0.3800			-0.0037	
	Y	1.3259	1.3200			0.0059	
□ 33 7_B1(3)	GDT Po2d	0.0139	0.0000	0.0200		0.0139	—
	X	0.3764	0.3800			-0.0036	
	Y	2.2759	2.2700			0.0059	
□ 33 7_B1(4)	GDT Po2d	0.0136	0.0000	0.0200		0.0136	—
	X	0.3764	0.3800			-0.0036	
	Y	3.2258	3.2200			0.0058	
□ 33 7_B1(5)	GDT Po2d	0.0132	0.0000	0.0200		0.0132	—
	X	0.3767	0.3800			-0.0033	
	Y	4.1757	4.1700			0.0057	
□ 33 7_B1(6)	GDT Po2d	0.0127	0.0000	0.0200		0.0127	—
	X	0.3768	0.3800			-0.0032	
	Y	5.1255	5.1200			0.0055	
□ 33 7_B1(7)	GDT Po2d	0.0125	0.0000	0.0200		0.0125	—
	X	0.3767	0.3800			-0.0033	
	Y	6.0753	6.0700			0.0053	
□ 32b 7_C1(1)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—
□ 32b 7_C1(2)	D	0.1284	0.1290	0.0050	-0.0010	-0.0006	—
□ 32b 7_C1(3)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—
□ 32b 7_C1(4)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—
□ 32b 7_C1(5)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—
□ 32b 7_C1(6)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—
□ 32b 7_C1(7)	D	0.1284	0.1290	0.0050	-0.0010	-0.0006	—
□ 32b 7_C1(8)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—
□ 32b 7_C1(9)	D	0.1284	0.1290	0.0050	-0.0010	-0.0006	—
□ 32b 7_C1(10)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—

Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<- >
☐ 34 7_C2(1)	GDT Po2d	0.0082	0.0000	0.0200		0.0082	├─
	X	1.0016	1.0000			0.0016	
	Y	-0.3138	-0.3100			-0.0038	
☐ 34 7_C2(2)	GDT Po2d	0.0082	0.0000	0.0200		0.0082	├─
	X	1.7517	1.7500			0.0017	
	Y	-0.3137	-0.3100			-0.0037	
☐ 34 7_C2(3)	GDT Po2d	0.0082	0.0000	0.0200		0.0082	├─
	X	2.5015	2.5000			0.0015	
	Y	-0.3138	-0.3100			-0.0038	
☐ 34 7_C2(4)	GDT Po2d	0.0080	0.0000	0.0200		0.0080	├─
	X	3.2514	3.2500			0.0014	
	Y	-0.3138	-0.3100			-0.0038	
☐ 34 7_C2(5)	GDT Po2d	0.0076	0.0000	0.0200		0.0076	├─
	X	4.0012	4.0000			0.0012	
	Y	-0.3136	-0.3100			-0.0036	
☐ 34 7_C2(6)	GDT Po2d	0.0074	0.0000	0.0200		0.0074	├─
	X	4.7510	4.7500			0.0010	
	Y	-0.3136	-0.3100			-0.0036	
☐ 34 7_C2(7)	GDT Po2d	0.0071	0.0000	0.0200		0.0071	├─
	X	5.5011	5.5000			0.0011	
	Y	-0.3134	-0.3100			-0.0034	
☐ 34 7_C2(8)	GDT Po2d	0.0068	0.0000	0.0200		0.0068	├─
	X	6.2510	6.2500			0.0010	
	Y	-0.3133	-0.3100			-0.0033	
☐ 34 7_C2(9)	GDT Po2d	0.0065	0.0000	0.0200		0.0065	├─
	X	7.0009	7.0000			0.0009	
	Y	-0.3131	-0.3100			-0.0031	
☐ 34 7_C2(10)	GDT Po2d	0.0061	0.0000	0.0200		0.0061	├─
	X	7.7508	7.7500			0.0008	
	Y	-0.3129	-0.3100			-0.0029	
☐ 32c 7_C1(1)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	├─┤
☐ 32c 7_C1(2)	D	0.1284	0.1290	0.0050	-0.0010	-0.0006	├─┤
☐ 32c 7_C1(3)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	├─┤
☐ 32c 7_C1(4)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	├─┤
☐ 32c 7_C1(5)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	├─┤
☐ 32c 7_C1(6)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	├─┤
☐ 32c 7_C1(7)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	├─┤
☐ 32c 7_C1(8)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	├─┤
☐ 32c 7_C1(9)	D	0.1284	0.1290	0.0050	-0.0010	-0.0006	├─┤
☐ 32c 7_C1(10)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	├─┤
☐ 32c 7_C1(11)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	├─┤
☐ 32c 7_C1(12)	D	0.1284	0.1290	0.0050	-0.0010	-0.0006	├─┤
☐ 32c 7_C1(13)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	├─┤
☐ 32c 7_C1(14)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	├─┤
☐ 32c 7_C1(15)	D	0.1302	0.1290	0.0050	-0.0010	0.0012	├─┤
☐ 32c 7_C1(16)	D	0.1305	0.1290	0.0050	-0.0010	0.0015	├─┤
☐ 32c 7_C1(17)	D	0.1307	0.1290	0.0050	-0.0010	0.0017	├─┤
☐ 35 7_C4(1)	GDT Po2d	0.0067	0.0000	0.0200		0.0067	├─
	X	0.4999	0.4990			0.0009	
	Y	-0.3132	-0.3100			-0.0032	

Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<— —>
□ 35 7_C4(2)	GDT Po2d	0.0070	0.0000	0.0200		0.0070	└
	X	1.2599	1.2590			0.0009	
	Y	-0.3134	-0.3100			-0.0034	
□ 35 7_C4(3)	GDT Po2d	0.0073	0.0000	0.0200		0.0073	└
	X	2.0198	2.0190			0.0008	
	Y	-0.3135	-0.3100			-0.0035	
□ 35 7_C4(4)	GDT Po2d	0.0074	0.0000	0.0200		0.0074	└
	X	2.7796	2.7790			0.0006	
	Y	-0.3136	-0.3100			-0.0036	
□ 35 7_C4(5)	GDT Po2d	0.0076	0.0000	0.0200		0.0076	└
	X	3.5395	3.5390			0.0005	
	Y	-0.3138	-0.3100			-0.0038	
□ 35 7_C4(6)	GDT Po2d	0.0076	0.0000	0.0200		0.0076	└
	X	4.2994	4.2990			0.0004	
	Y	-0.3138	-0.3100			-0.0038	
□ 35 7_C4(7)	GDT Po2d	0.0076	0.0000	0.0200		0.0076	└
	X	5.0593	5.0590			0.0003	
	Y	-0.3138	-0.3100			-0.0038	
□ 35 7_C4(8)	GDT Po2d	0.0075	0.0000	0.0200		0.0075	└
	X	5.8192	5.8190			0.0002	
	Y	-0.3137	-0.3100			-0.0037	
□ 35 7_C4(9)	GDT Po2d	0.0073	0.0000	0.0200		0.0073	└
	X	6.5790	6.5790			0.0000	
	Y	-0.3137	-0.3100			-0.0037	
□ 35 7_C4(10)	GDT Po2d	0.0071	0.0000	0.0200		0.0071	└
	X	7.3390	7.3390			0.0000	
	Y	-0.3136	-0.3100			-0.0036	
□ 35 7_C4(11)	GDT Po2d	0.0069	0.0000	0.0200		0.0069	└
	X	8.0988	8.0990			-0.0002	
	Y	-0.3135	-0.3100			-0.0035	
□ 35 7_C4(12)	GDT Po2d	0.0065	0.0000	0.0200		0.0065	└
	X	8.8587	8.8590			-0.0003	
	Y	-0.3133	-0.3100			-0.0033	
□ 35 7_C4(13)	GDT Po2d	0.0062	0.0000	0.0200		0.0062	└
	X	9.6186	9.6190			-0.0004	
	Y	-0.3131	-0.3100			-0.0031	
□ 35 7_C4(14)	GDT Po2d	0.0059	0.0000	0.0200		0.0059	└
	X	10.3785	10.3790			-0.0005	
	Y	-0.3129	-0.3100			-0.0029	
□ 35 7_C4(15)	GDT Po2d	0.0058	0.0000	0.0200		0.0058	└
	X	11.1380	11.1390			-0.0010	
	Y	-0.3127	-0.3100			-0.0027	
□ 35 7_C4(16)	GDT Po2d	0.0055	0.0000	0.0200		0.0055	└
	X	11.8981	11.8990			-0.0009	
	Y	-0.3126	-0.3100			-0.0026	
□ 35 7_C4(17)	GDT Po2d	0.0050	0.0000	0.0200		0.0050	└
	X	12.6581	12.6590			-0.0009	
	Y	-0.3124	-0.3100			-0.0024	
□ 32d 7_C1(1)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—┘
□ 32d 7_C1(2)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—┘
□ 32d 7_C1(3)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—┘
□ 32d 7_C1(4)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—┘
□ 32d 7_C1(5)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—┘
□ 32d 7_C1(6)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—┘

Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<— —>
☐ 36 7_B8(1)	GDT Po2d	0.0137	0.0000	0.0200		0.0137	—
	X	-0.3032	-0.3100			0.0068	
	Y	0.3098	0.3100			-0.0002	
☐ 36 7_B8(2)	GDT Po2d	0.0126	0.0000	0.0200		0.0126	—
	X	-0.3037	-0.3100			0.0063	
	Y	1.0600	1.0600			0.0000	
☐ 36 7_B8(3)	GDT Po2d	0.0115	0.0000	0.0200		0.0115	—
	X	-0.3043	-0.3100			0.0057	
	Y	1.8101	1.8100			0.0001	
☐ 36 7_B8(4)	GDT Po2d	0.0106	0.0000	0.0200		0.0106	—
	X	-0.3047	-0.3100			0.0053	
	Y	2.5603	2.5600			0.0003	
☐ 36 7_B8(5)	GDT Po2d	0.0096	0.0000	0.0200		0.0096	—
	X	-0.3052	-0.3100			0.0048	
	Y	3.3103	3.3100			0.0003	
☐ 36 7_B8(6)	GDT Po2d	0.0089	0.0000	0.0200		0.0089	—
	X	-0.3056	-0.3100			0.0044	
	Y	4.0604	4.0600			0.0004	
☐ 32e 7_C1	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—
☐ 37 7_B9	GDT Po2d	0.0073	0.0000	0.0200		0.0073	—
	X	-0.3118	-0.3100			-0.0018	
	Y	0.7418	0.7450			-0.0032	
☐ 32f 7_C8(1)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—
☐ 32f 7_C8(2)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—
☐ 38 7_C7(1)	GDT Po2d	0.0025	0.0000	0.0200		0.0025	—
	X	-0.3113	-0.3100			-0.0013	
	Y	0.6249	0.6250			-0.0001	
☐ 38 7_C7(2)	GDT Po2d	0.0013	0.0000	0.0200		0.0013	—
	X	-0.3106	-0.3100			-0.0006	
	Y	1.2498	1.2500			-0.0002	
☐ 32g 7_C1	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—
☐ 39 7_B3	GDT Po2d	0.0111	0.0000	0.0200		0.0111	—
	X	-0.3155	-0.3100			-0.0055	
	Y	0.3809	0.3800			0.0009	
☐ 32h 7_C1	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—
☐ 40 7_B3	GDT Po2d	0.0060	0.0000	0.0200		0.0060	—
	X	-0.2686	-0.2660			-0.0027	
	Y	2.1014	2.1000			0.0014	
☐ 32i 7_C1	D	0.1285	0.1285	0.0050	-0.0010	0.0000	—
☐ 41 7_B3	GDT Po2d	0.0105	0.0000	0.0200		0.0105	—
	X	-0.0284	-0.0250			-0.0034	
	Y	2.8640	2.8600			0.0040	
☐ 32j 7_C1	D	0.1290	0.1290	0.0050	-0.0010	0.0000	—
☐ 42 7_B3	GDT Po2d	0.0124	0.0000	0.0200		0.0124	—
	X	1.4531	1.4560			-0.0029	
	Y	4.3454	4.3400			0.0054	
☐ 32k 7_C1	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—
☐ 43 7_B3	GDT Po2d	0.0189	0.0000	0.0200		0.0189	—
	X	3.5678	3.5600			0.0078	
	Y	0.3153	0.3100			0.0053	
☐ 32L 7_C1(1)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—
☐ 32L 7_C1(2)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—
☐ 32L 7_C1(3)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—

Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<- >
☐ 32L 7_C1(4)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—
☐ 32L 7_C1(5)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—
☐ 32L 7_C1(6)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—
☐ 32L 7_C1(7)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—
☐ 44 7_B3,B4(1)	GDT Po2d	0.0132	0.0000	0.0200		0.0132	—
	X	4.0058	4.0000			0.0058	
	Y	0.3132	0.3100			0.0032	
☐ 44 7_B3,B4(2)	GDT Po2d	0.0133	0.0000	0.0200		0.0133	—
	X	5.0059	5.0000			0.0059	
	Y	0.3131	0.3100			0.0031	
☐ 44 7_B3,B4(3)	GDT Po2d	0.0133	0.0000	0.0200		0.0133	—
	X	6.0059	6.0000			0.0059	
	Y	0.3130	0.3100			0.0030	
☐ 44 7_B3,B4(4)	GDT Po2d	0.0136	0.0000	0.0200		0.0136	—
	X	8.0059	8.0000			0.0059	
	Y	0.3133	0.3100			0.0033	
☐ 44 7_B3,B4(5)	GDT Po2d	0.0138	0.0000	0.0200		0.0138	—
	X	9.0059	9.0000			0.0059	
	Y	0.3135	0.3100			0.0035	
☐ 44 7_B3,B4(6)	GDT Po2d	0.0140	0.0000	0.0200		0.0140	—
	X	10.0060	10.0000			0.0060	
	Y	0.3137	0.3100			0.0037	
☐ 44 7_B3,B4(7)	GDT Po2d	0.0143	0.0000	0.0200		0.0143	—
	X	11.0059	11.0000			0.0059	
	Y	0.3141	0.3100			0.0041	
☐ 32m 7_C1	D	0.1287	0.1290	0.0050	-0.0010	-0.0003	—
☐ 45 7_A4	GDT Po2d	0.0149	0.0000	0.0200		0.0149	—
	X	12.9260	12.9300			-0.0040	
	Y	4.5263	4.5200			0.0063	
☐ 32n 7_C1(1)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—
☐ 32n 7_C1(2)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—
☐ 32n 7_C1(3)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—
☐ 32n 7_C1(4)	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—
☐ 32n 7_C1(5)	D	0.1285	0.1290	0.0050	-0.0010	-0.0005	—
☐ 46 7_B6(1)	GDT Po2d	0.0070	0.0000	0.0200		0.0070	—
	X	0.8761	0.8750			0.0011	
	Y	0.3133	0.3100			0.0033	
☐ 46 7_B6(2)	GDT Po2d	0.0078	0.0000	0.0200		0.0078	—
	X	1.7512	1.7500			0.0012	
	Y	0.3137	0.3100			0.0037	
☐ 46 7_B6(3)	GDT Po2d	0.0081	0.0000	0.0200		0.0081	—
	X	2.6262	2.6250			0.0012	
	Y	0.3139	0.3100			0.0039	
☐ 46 7_B6(4)	GDT Po2d	0.0087	0.0000	0.0200		0.0087	—
	X	3.5011	3.5000			0.0011	
	Y	0.3142	0.3100			0.0042	
☐ 46 7_B6(5)	GDT Po2d	0.0093	0.0000	0.0200		0.0093	—
	X	4.3762	4.3750			0.0012	
	Y	0.3145	0.3100			0.0045	
☐ 32o 7_C1	D	0.1286	0.1290	0.0050	-0.0010	-0.0004	—
☐ 47 7_B7	GDT Po2d	0.0158	0.0000	0.0200		0.0158	—
	X	0.3179	0.3100			0.0079	
	Y	0.4995	0.5000			-0.0005	

Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-- -->
☐ 48a 8_A5	D	0.2037	0.2010	0.0050	-0.0010	0.0027	┆
☐ 49 8_C6	GDT Po2d	0.0103	0.0000	0.0600		0.0103	┆
	X	-0.3151	-0.3100			-0.0051	
	Y	1.1309	1.1300			0.0009	
☐ 48b 8_A5	D	0.2038	0.2010	0.0050	-0.0010	0.0028	┆
☐ 50 8_C6	GDT Po2d	0.0100	0.0000	0.0600		0.0100	┆
	X	0.6033	0.6060			-0.0027	
	Y	3.7142	3.7100			0.0042	
☐ 48c 8_A5	D	0.2037	0.2010	0.0050	-0.0010	0.0027	┆
☐ 51 8_C7	GDT Po2d	0.0131	0.0000	0.0600		0.0131	┆
	X	2.7529	2.7500			0.0029	
	Y	0.3159	0.3100			0.0059	
☐ 48d 8_A5	D	0.2037	0.2010	0.0050	-0.0010	0.0027	┆
☐ 52 8_B6	GDT Po2d	0.0136	0.0000	0.0600		0.0136	┆
	X	7.0063	7.0000			0.0063	
	Y	0.3125	0.3100			0.0025	
☐ 48e 8_A5	D	0.2037	0.2010	0.0050	-0.0010	0.0027	┆
☐ 53 8_B5	GDT Po2d	0.0145	0.0000	0.0600		0.0145	┆
	X	12.0060	12.0000			0.0060	
	Y	0.3140	0.3100			0.0040	
☐ 48f 8_A5	D	0.2036	0.2010	0.0050	-0.0010	0.0026	┆
☐ 54 8_B4,C2	GDT Po2d	0.0326	0.0000	0.0600		0.0326	┆
	X	17.0946	17.0900			0.0046	
	Y	1.3256	1.3100			0.0156	
☐ 55a 8_A4(1)	D	0.0986	0.0980	0.0040	-0.0010	0.0006	┆
☐ 55a 8_A4(2)	D	0.0987	0.0980	0.0040	-0.0010	0.0007	┆
☐ 56a 8_A4(1)	GDT Po2d	0.0005	0.0000	0.0600		0.0005	┆
	X	-0.0002	0.0000			-0.0002	
	Y	-0.3439	-0.3440			0.0001	
☐ 56a 8_A4(2)	GDT Po2d	0.0002	0.0000	0.0600		0.0002	┆
	X	-0.0001	0.0000			-0.0001	
	Y	0.3440	0.3440			0.0000	
☐ 57a 8_A4_R	Dist	0.6873	0.6880	0.0100	-0.0100	-0.0007	┆
☐ 55b 8_A4(1)	D	0.0985	0.0980	0.0040	-0.0010	0.0005	┆
☐ 55b 8_A4(2)	D	0.0986	0.0980	0.0040	-0.0010	0.0006	┆
☐ 56b 8_A4(1)	GDT Po2d	0.0004	0.0000	0.0600		0.0004	┆
	X	0.0001	0.0000			0.0001	
	Y	-0.3442	-0.3440			-0.0002	
☐ 56b 8_A4(2)	GDT Po2d	0.0005	0.0000	0.0600		0.0005	┆
	X	-0.0001	0.0000			-0.0001	
	Y	0.3438	0.3440			-0.0002	
☐ 57b 8_A4_R	Dist	0.6876	0.6880	0.0100	-0.0100	-0.0004	┆
☐ 55c 8_A4(1)	D	0.0987	0.0980	0.0040	-0.0010	0.0007	┆
☐ 55c 8_A4(2)	D	0.0986	0.0980	0.0040	-0.0010	0.0006	┆
☐ 56c 8_A4(1)	GDT Po2d	0.0005	0.0000	0.0600		0.0005	┆
	X	-0.3442	-0.3440			-0.0002	
	Y	0.0002	0.0000			0.0002	
☐ 56c 8_A4(2)	GDT Po2d	0.0006	0.0000	0.0600		0.0006	┆
	X	0.3438	0.3440			-0.0002	
	Y	0.0002	0.0000			0.0002	
☐ 57c 8_A4_R	Dist	0.6880	0.6880	0.0100	-0.0100	0.0000	┆
☐ 55d 8_A4(1)	D	0.0987	0.0980	0.0040	-0.0010	0.0007	┆

Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<- ->
☐ 55d 8_A4(2)	D	0.0984	0.0980	0.0040	-0.0010	0.0004	-
☐ 56d 8_A4(1)	GDT Po2d	0.0004	0.0000	0.0600		0.0004	-
	X	-0.3442	-0.3440			-0.0002	
	Y	0.0001	0.0000			0.0001	
☐ 56d 8_A4(2)	GDT Po2d	0.0005	0.0000	0.0600		0.0005	-
	X	0.3438	0.3440			-0.0002	
	Y	0.0002	0.0000			0.0002	
☐ 57d 8_A4_R	Dist	0.6878	0.6880	0.0100	-0.0100	-0.0002	-
☐ 55e 8_A4(1)	D	0.0988	0.0980	0.0040	-0.0010	0.0008	-
☐ 55e 8_A4(2)	D	0.0986	0.0980	0.0040	-0.0010	0.0006	-
☐ 56e 8_A4(1)	GDT Po2d	0.0016	0.0000	0.0600		0.0016	-
	X	-0.3440	-0.3440			0.0000	
	Y	-0.0008	0.0000			-0.0008	
☐ 56e 8_A4(2)	GDT Po2d	0.0012	0.0000	0.0600		0.0012	-
	X	0.3440	0.3440			0.0000	
	Y	0.0006	0.0000			0.0006	
☐ 57e 8_A4_R	Dist	0.6879	0.6880	0.0100	-0.0100	-0.0001	-
☐ 55f 8_A4(1)	D	0.0986	0.0980	0.0040	-0.0010	0.0006	-
☐ 55f 8_A4(2)	D	0.0988	0.0980	0.0040	-0.0010	0.0008	-
☐ 56f 8_A4(1)	GDT Po2d	0.0010	0.0000	0.0600		0.0010	-
	X	-0.3444	-0.3440			-0.0004	
	Y	-0.0003	0.0000			-0.0003	
☐ 56f 8_A4(2)	GDT Po2d	0.0006	0.0000	0.0600		0.0006	-
	X	0.3439	0.3440			-0.0001	
	Y	-0.0002	0.0000			-0.0002	
☐ 57f 8_A4_R	Dist	0.6882	0.6880	0.0100	-0.0100	0.0002	-

Manually Inspected Dims

58	6_B3	.125 typ. wall thickness	<u>.1235/.1285</u>
59	6_A3	.125 typ. flange thk	<u>.1187/.128</u>
60	6_B2	R.06	<u>R.06 typ.</u>
61	6_B2	R.16	<u>R.16 typ.</u>
62	6_D2	2.87 dim	<u>2.91</u>
63	6_D2	1.85 dim	<u>1.89</u>
64	6_D2	1.14 dim	<u>1.15</u>
65	6_D2	135 deg angle	<u>135°</u>
66	6_D4	18.62 dim	<u>18.58</u>
67	6_D8	1.43 dim	<u>1.47</u>
68	6_D8	0.83 dim	<u>.84</u>
69	6_D7	143 deg angle	<u>143°</u>
70	6_D7	R0.13 typ	<u>R.16 typ.</u>
71	7_C7	CSK .220 dia x 100 deg	<u>.227/.230 x 100°</u>
72	7_A6	0.063 dim typ.	<u>.061/.0635</u>
73	7_A5	R0.063 typ.	<u>R.125 typ.</u>
74	8_C5	CSK .170 dia x 100 deg	<u>.160/.170 x 100°</u>
75	8_C5	CSK .120 dia x 100 deg	<u>.113/.115 x 100°</u>